

Work Order ID 72387

Monday, July 25, 2011 9:17:57 AM



Item ID: D4355-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 7/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

11-07-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4355

B

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D4355-1 File

B11-8-16

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB049 and Dwg

FOLIO REV: *B*

DWG REV: *B*

3-Deburr

FK. 11/10/30

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				8	8		
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	8		
151 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							

F.K. 11/10/30

and 11/10/31

PPR 72387
PPR 44

11/10/31 (8)

Dart Aerospace Ltd

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Picklist Print

Monday, July 25, 2011 9:18:02 AM

Page 1

Work Order ID: 72387



Parent Item: D4355-1



Parent Item Name: Bearpaw

Start Date: 7/25/2011

Required Date: 8/25/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-04-11 JLMN VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10		Purchased	No			120	sf	501.2200	5.3	44.63158			
----------	--	-----------	----	--	--	-----	----	----------	-----	----------	--	--	--



UHMW 1" Black



1811-8-16

Location

Loc Qty

Loc Code

MAT018

501.22

117321

76.6

117738

166.3

117819

129.9

118257

128.42

118257

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DART AEROSPACE LTD		Work Order: 72387
Description: D4355-1 Bearpaw		Part Number: D4355-1
Inspection Dwg: D4355-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.00	+/- .030	27.00	✓		FK-05	tape -
24.00	+/- .030	24.00	✓		"	"
4.250	+/- .010	4.245	✓		FK-04	Vern -
2.76	+/- .030	2.754	✓		"	"
1.22	+/- .030	1.206	✓		"	"
6.625	+/- .010	6.625	✓		CNC-02	"
4.000	+/- .010	4.000	✓		FK-04	"
.38	+/- .030	.383	✓		"	"
R.25	+/- .030	.25	✓		rad gauge	
.95	+/- .030	.945	✓		FK-04	Vern
.63	+/- .030	.625	✓		"	"
.30 x 45°	+/- .030	.27 x 45°	✓		"	"
21.38	+/- .030	21.38	✓		FK-05	tape
1.31	+/- .030	1.31	✓		FK-04	Vern
.75	+/- .030	.751	✓		"	"
2.75	+/- .030	2.745	✓		"	"
.25	+/- .030	.245	✓		"	"
.38	+/- .030	.396	✓		"	"
Ø.261	+/- .005 / - .001	.260	✓		"	"
Ø.650	+/- .030	.645	✓		"	"
.50	+/- .030	.530	✓		"	"
.06 x 45°	+/- .030	.06 x 45°	✓		"	"
.07 x 45°	+/- .030	.082 x 45°	✓		"	"

Measured by: FK	Audited by: [Signature]	Preliminary Approval:
Date: 11/10/30	Date: 11/10/31	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

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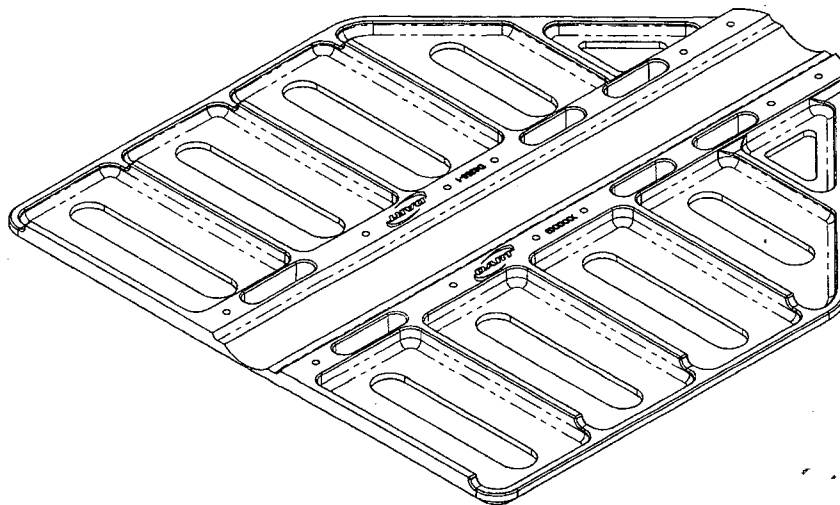
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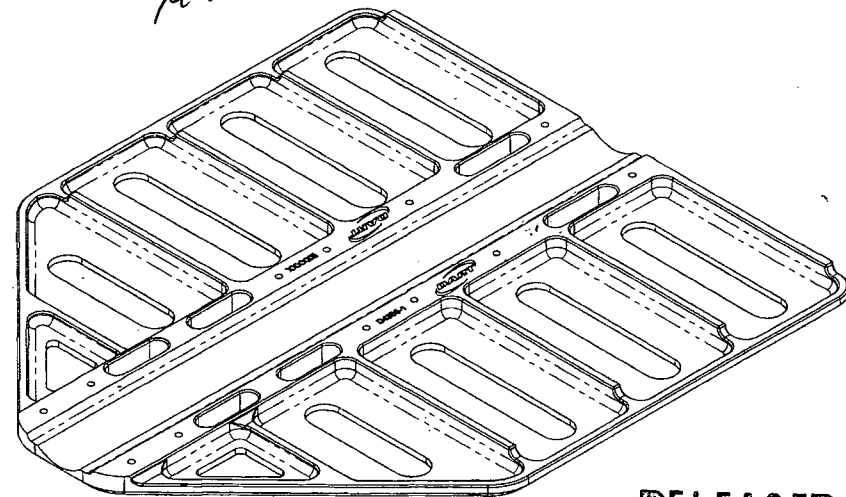
NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 77387


11-05-25



D4355-1 206L/407 BEARPAW



RELEASED
 2011-05-15
MD

- NOTES:
 1) MATERIAL: UHMW BLACK SPEC CONTROL DRAWING D2689, 1.000 THICK.
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4355-1" AND B/N "BXXXXX"
 0.010 - 0.012 DP AS SHOWN
 7) WEIGHT: 6.88 lbs
 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP. 

B	SHT 1 WEIGHT CORRECTED WAS 8.41 lbs. SHT 2 RIB DIMS UPDATED. ZN B4 RAD WAS 2.00. SHT 3, SECT. B-B RIB HEIGHT INCREASED. ALL SHTS DART LOGO UPDATED.		AJS	11.04.26
A	NEW ISSUE		AJS	11.03.21
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4355 REV. B SHEET 1 OF 3 TITLE 206L/407 BEARPAW SCALE NTS DATE 11.04.26 <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	AJS			
CHECKED	<i>MD</i>			
MFG. APPR.	<i>MD</i>			
APPROVED	<i>MD</i>			
DE APPR.	<i>MD</i>			

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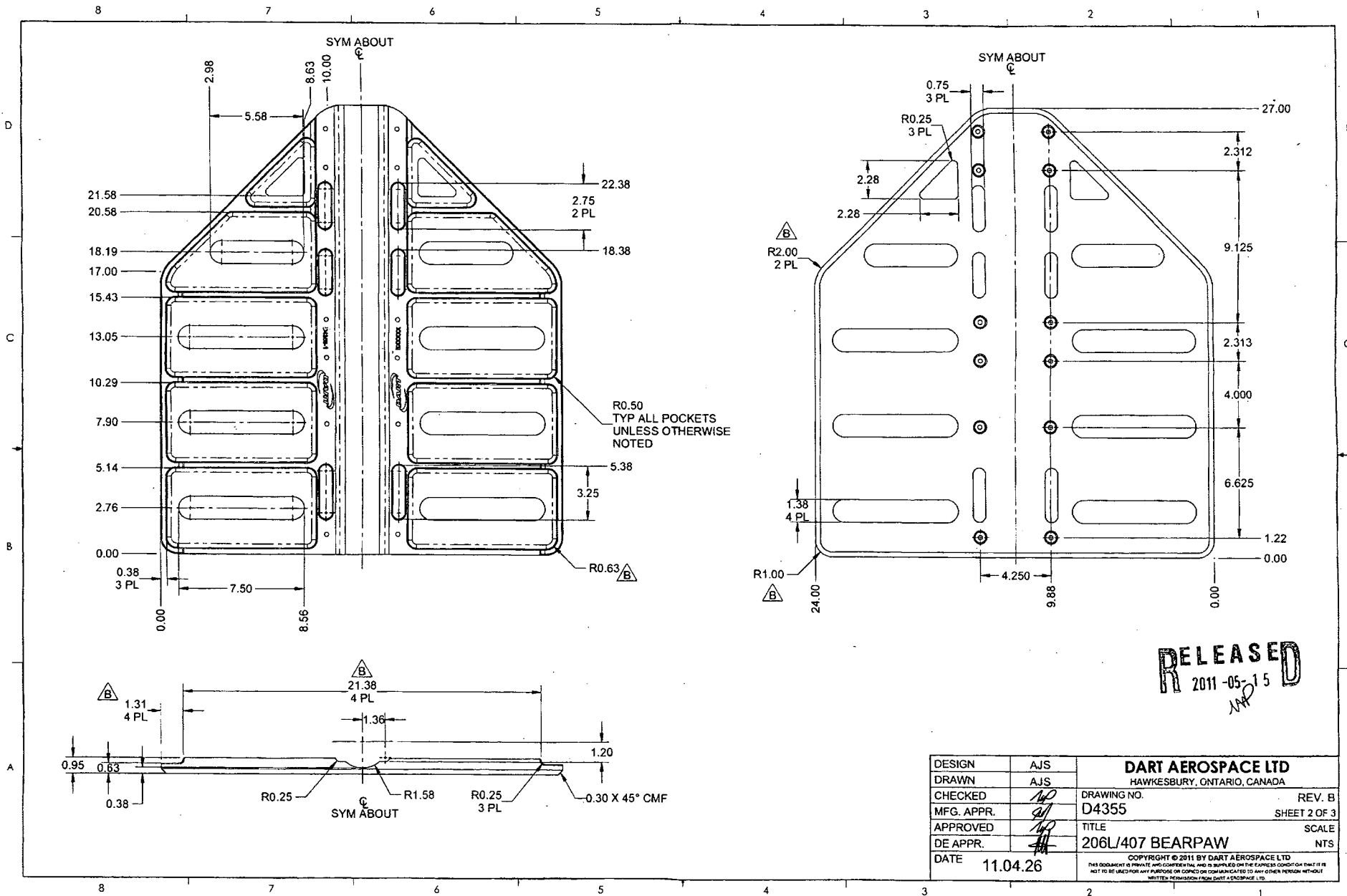
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12387



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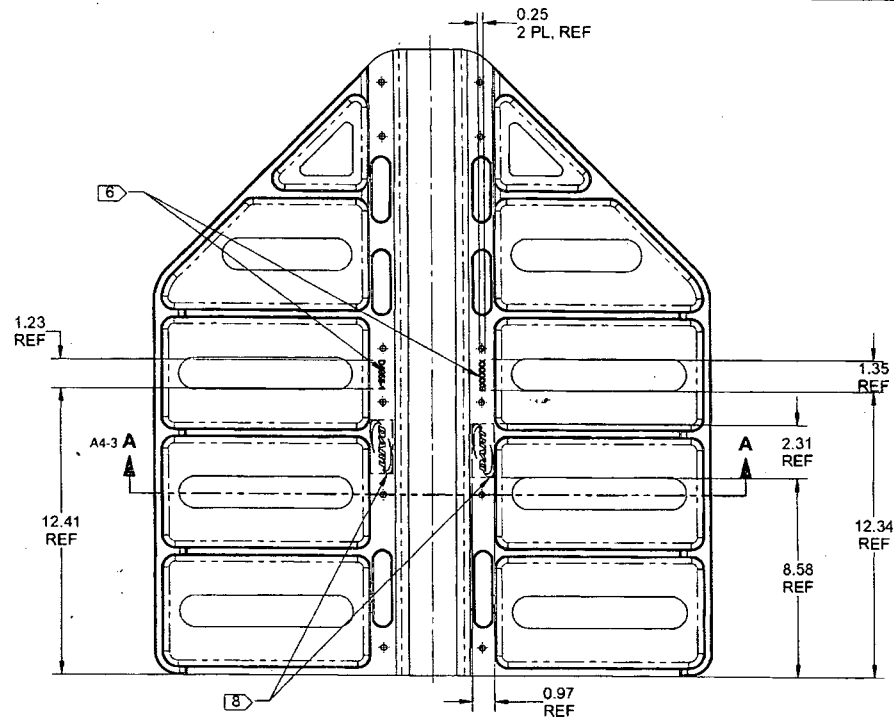
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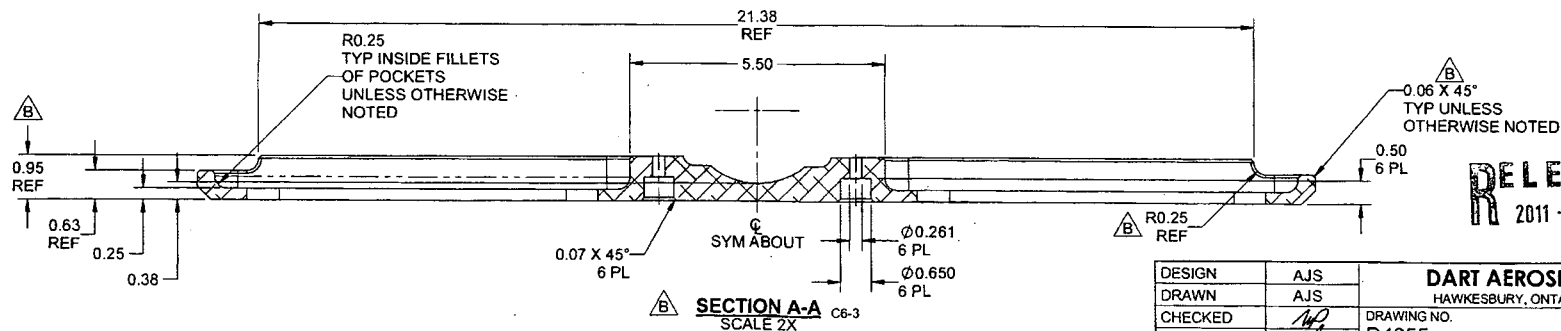
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72387



(SUPPLEMENTAL VIEW)



RELEASED
2011-05-15

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4355	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L/407 BEARPAW	NTS
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